

Date: Thursday, 4/12/2007 8:46:31 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 31737		
Estimate Number	: 10008		
P.O. Number	: N/A	Part Number	: D2591
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: D2591 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	: 31231	Material	: N/A
Written By	:	Due Date	: 5/5/2007 Qty: 60 Um: Each
Checked & Approved By	: [Signature]		
Comment	: Est Rev: Removed from 9 Digit 05-10-25 JLM		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"	
Comment: Qty.: 0.2340 f(s)/Unit Total : 14.0400 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: M103069 x 19 parts M104185 x 41 parts J.L 07/04/25			
2.0	BAND SAW	BAND SAW	
Comment: BAND SAW Cut blanks: 2.700" long			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591 2-Deburr if required J.L/J.F. 07/04/27 60			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.L/J.F. 07/04/27 60			
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK J.M 07/04/28 60			
6.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: E.P.A 07/04/30 60			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/05/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG

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Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



60

Comment: FINAL INSPECTION/W/O RELEASE

FD 07/05/01

Job Completion



U 07/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

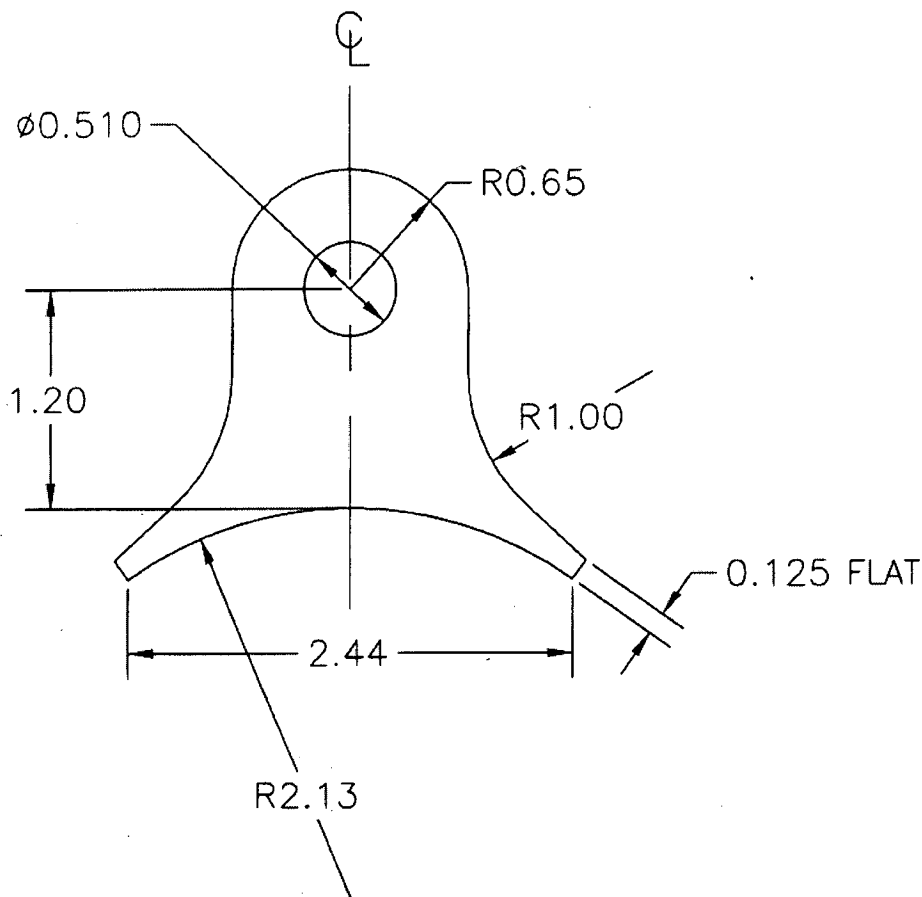
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>MEY</i>	DRAWN BY <i>MEY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED
98.01.21 DS



BREAK ALL SHARP CORNERS ~~0.010~~ TO 0.020

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING

CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 31737

